

Work Order ID 50396

July 14, 2009 2:39:31 PM



Page 1

Item ID: D3144-107 **BK**

Accept



Setup Start



Revision ID: C

Stop



Item Name: Doubler

Start Date: 7/15/09 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan **W**

Date: 09-07-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3144

Rev C

100

0.00



PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3144

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

W 09 08 20 (4)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W 09 08 20 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Debur if necessary

u/a S

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> M1 09/08/20

(X4) Ø

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Item ID: D3144-107

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Setup Start



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Item Name: Doubler

Start Date: 7/15/09

Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:50am

OVEN TEMPERATURE: 320°F

FINISH TIME: 8:20am

=> 8/09/08/24

4x

Ø

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BK 09-08-24

④

170

Identify as per dwg & Stock Location: CA

0.00



Packaging

Memo

0.00

Packaging

PC 9/1/04

④

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Item ID: D3144-107

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Setup Start



Revision ID: C

Stop



Item Name: Doubler

Start Date: 7/15/09

Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/25 *[Signature]*

MF 09-08-24

Picklist Print

July 15, 2009 11:56:48 AM

Page 1

Work Order ID: 50396

Parent Item: D3144-107RevC

Parent Item Name: Doubler

Comments:

Start Date: 07/15/2009

Required Date: 07/15/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No				sf	111.0100	1.1700			



2024-T3 .032 sheet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	111.01	
102942	1.5	
105555	5	
106272	8.47	
108595	3	
109240	7.02	
110778	34.02	
111699	49	
18147	3	

ml 09 08 20

DART AEROSPACE LTD	Work Order: 50396
Description: DOUBLER	Part Number: D3144-107
Inspection Dwg: D3144 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

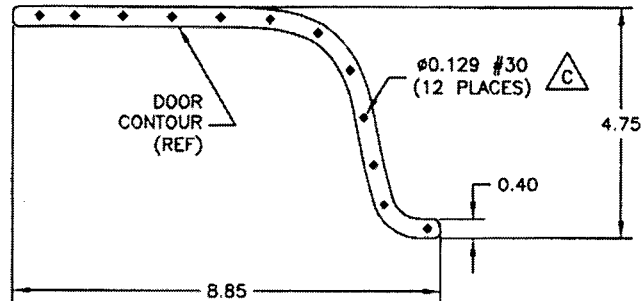
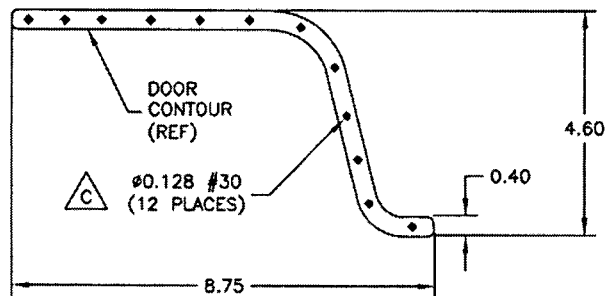
☒ **First Article** ☐ **Prototype**[illegible]

Measured by:	<i>md. md.</i>	Audited by:	<i>S</i>	Prototype Approval:	<i>a</i>
Date:	<i>09-08-20</i>	Date:	<i>09/08/20</i>	Date:	<i>9</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3144	REV. C SHEET 7 OF 9
DATE 05.10.19	TITLE DOUBLER		SCALE NTS

**D3144-107 DOUBLER (FOR D412-694-03)****D3144-121 DOUBLER (FOR D412-694-04)**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50396

RELEASED05.11.14 *[Signature]***D3144-107/-121 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C7.DWG"

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